

Date: Tuesday, 20/01/2009 2:31:45 PM
 User: Linda Lacelle

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLATE
 Job Number : 44951-1
 Estimate Number : 13738
 P.O. Number :
 This Issue : 20/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 09-04-19 as per prelim issue DD verified by:ec

Part Number : D38661
 Drawing Number : D3866 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 26/01/2009 Qty: 4 Um: Each

POSITIVE RECALL

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0662 sf(s)/Unit Total : 0.2646 sf(s)
 6061-T6 .125 Sheet
 batch: 110405 HB 9-1-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3866
 Dwg Rev: PRE
 Prog Rev: Lim

HB 9-1-21

6

2-Deburr if necessary

HB 9-1-21

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING APPROVAL



Comment: SECOND CHECK

HB 9-1-21

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- deburr
 2- form as per dwg D3866

SB 29/01/26

2

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 44951

Part Number: D38661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

09.01.26 (2x)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(2x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-F 09/01/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 09/01/27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA w/o 3866-041 B 44950-2

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17

Comment: FINAL INSPECTION/W/O RELEASE

09.01.28

Job Completion



POSITIVE RECALL

EFFECTIVE 09.01.21 AUTH

RELEASED 09.02.17 DATE

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

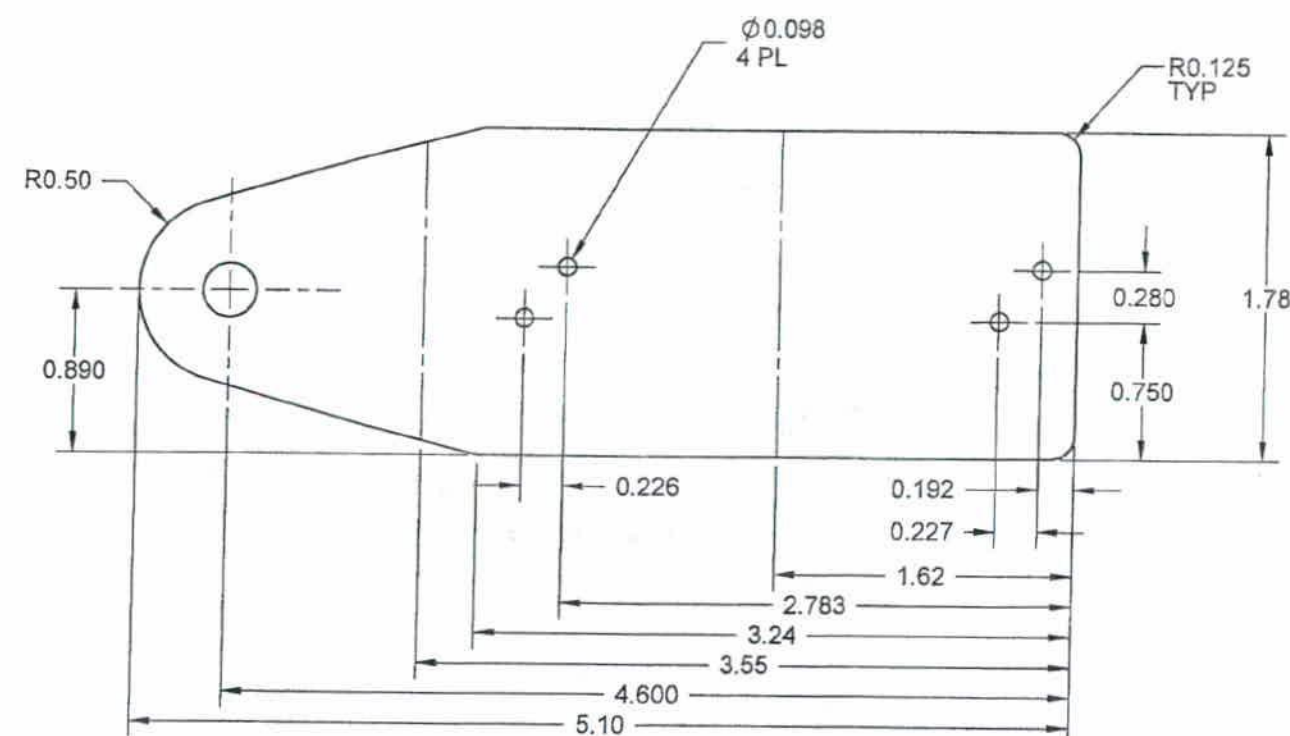
[illegible]

Measured by:	JB
Date:	9-1-71

Audited by:	by
Date:	09.06.21

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3866-1F PLATE FLAT PATTERN

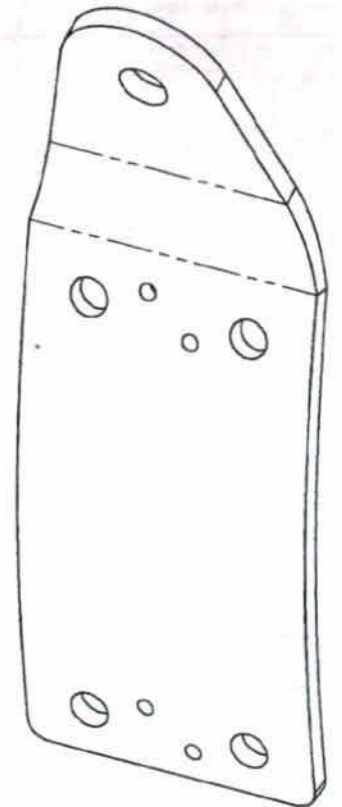
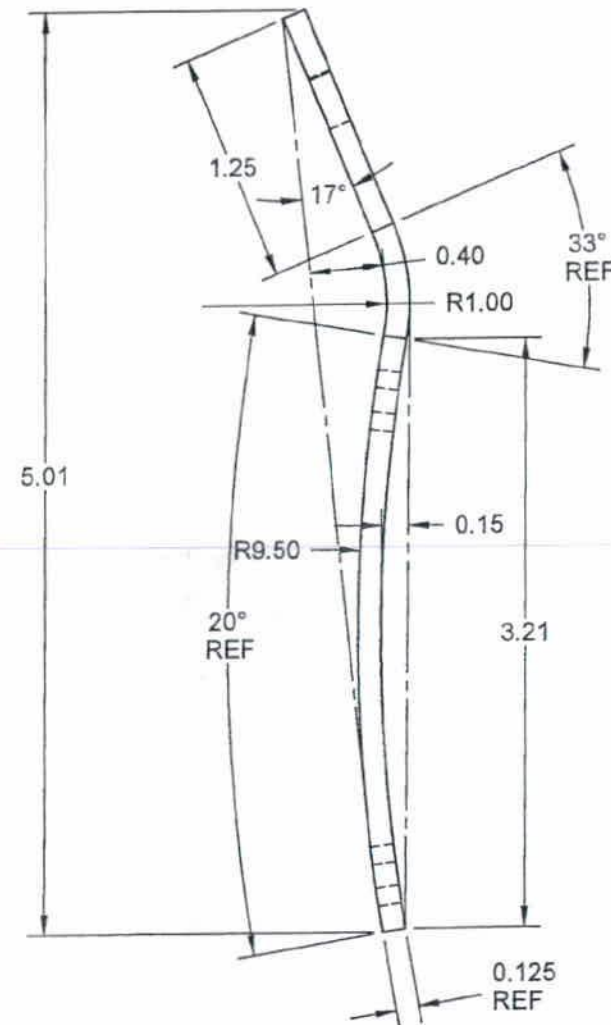
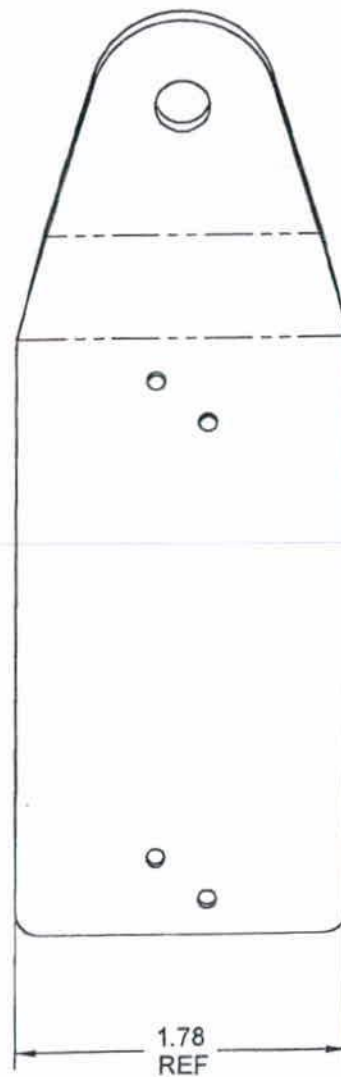
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3866	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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PRELIMINARY ISSUE
09/01/13

44951



D3866-1 PLATE
MADE FROM D3866-1F

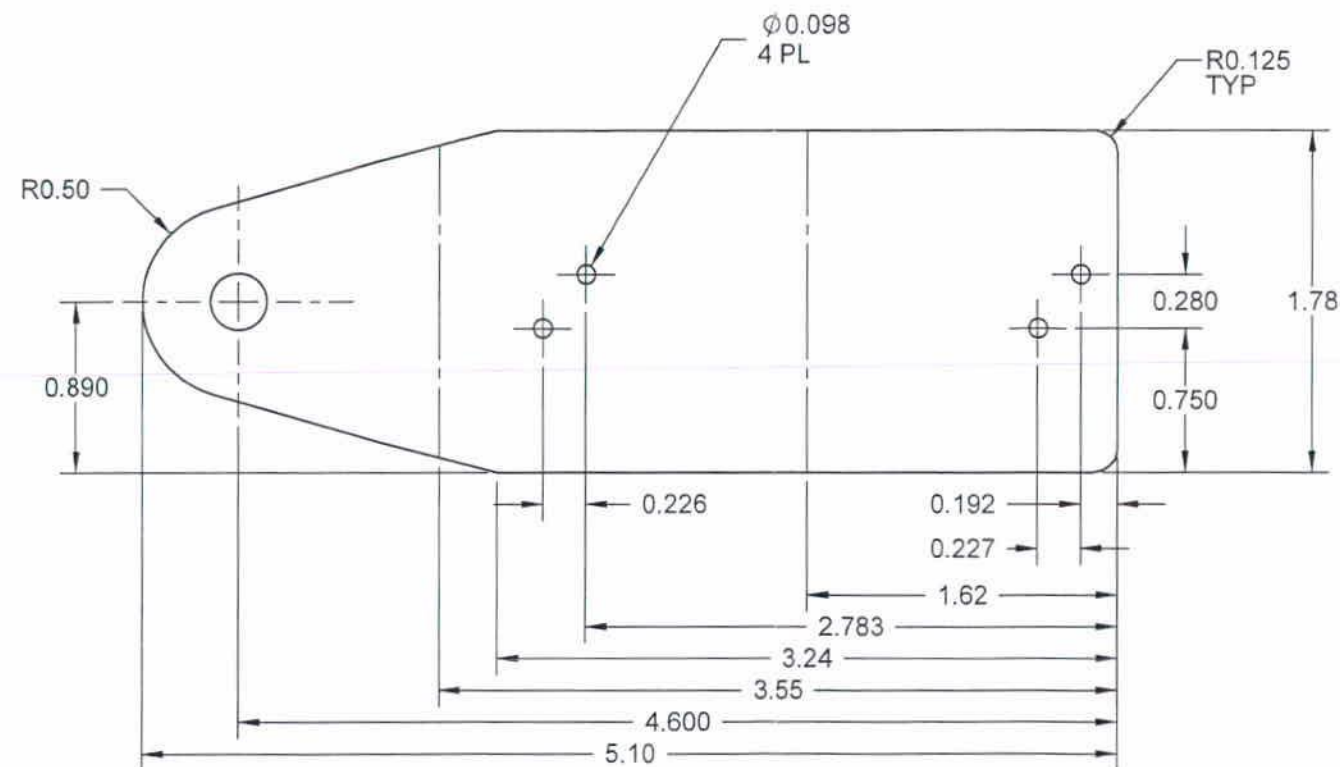
NOTES:

- 1) MATERIAL: MADE FROM D3866-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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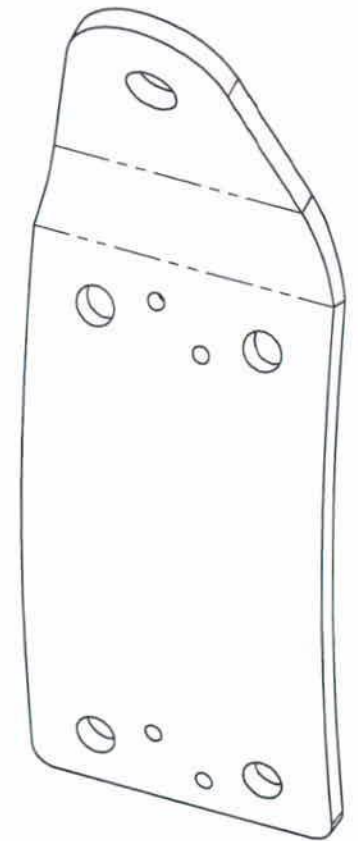
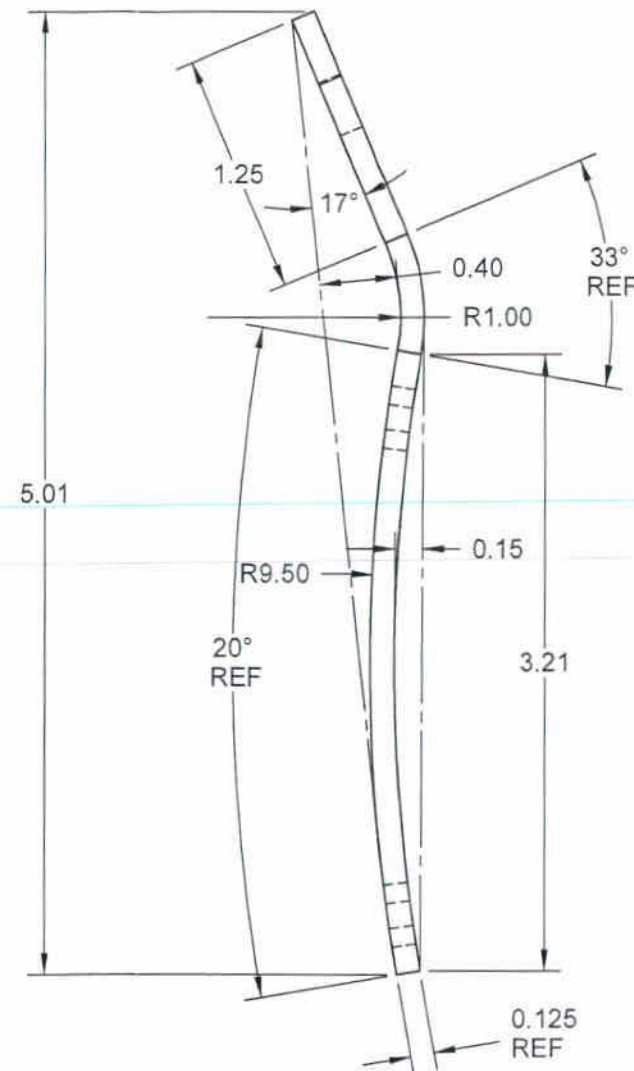
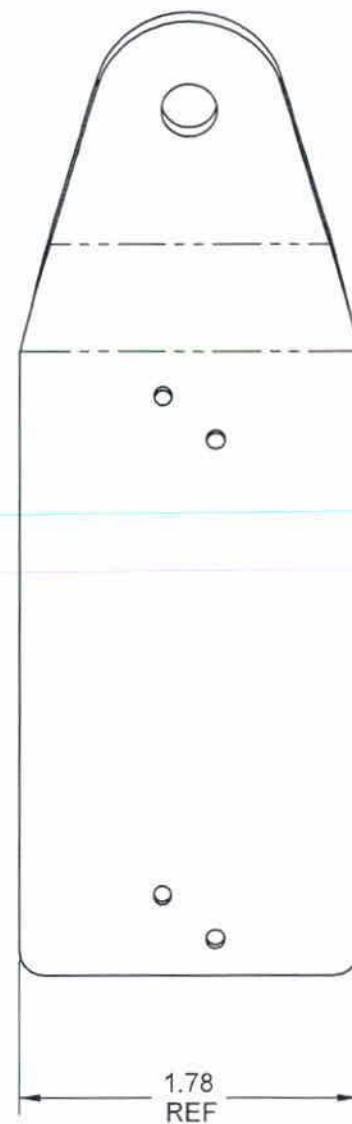


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D3866-1 PLATE
MADE FROM D3866-1F

NOTES:

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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RELEASED
07/21/29 MP

44957

